

Work Order ID 149955 -1

149955

Page 1

August 16, 2016 10:09:00 AM

Item ID: D5283-043 **SPLIT** Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: **9** Stop ***NS2***
 Item Name: Basket Clamp Assembly
 Start Date: 8/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/23/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: **Sgt** Date: AUG 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5283	A								
100		0.00							DAS 32 9-89
100						10	0		
Bandsaw	Memo	0.00							16-08-16
Jeaspa Bandsaw	CUT TO 5.5" LONG								
105		0.00							DAS 13 9-89
105						10			
Purchasing	Memo	0.00							
Purchasing	Issue p.o : 33342								
	Possible supplier: Metec								
	Machine, Alodine and powder Coat as per Dwg ***Note mask bore prior to powder coat***								
	C of C is required								

AUG 17 2016

DQA:

Date:

JAN 4 2017



QA Closed:

Date:

OCT 19 2016

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>149955</u> Part No. <u>DS283-043</u> NCR No. <u>16-6106</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒																																															
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Date : <u>16-08-25</u>		Step #: <u>100</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval																																																																	
Description Work Order Deviation				Disposition		<u>16-08-25</u> Completed By DAS 38 AUG 25 2016 Lead hand / Supervisor Approval Verification DAS 38 AUG 25 2016 QC / QA Coordinator Approval <u>16-08-25</u>																																																																	
<u>1 pcs hold is suppose to be between .8115 is .812 hold to big</u>				<u>Scrap / destroy no replace</u>																																																																			
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Work Order ID 149955

August 16, 2016 9:23:56 AM

149955

Page 3

Item ID: D5283-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Clamp Assembly
 Start Date: 8/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/23/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									
									DAS 38 9-89 SEP 15 2016
210	Identify as per dwg & Stock Location: <u>Sts23</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
									DAS 6 9-89 SEP 16 2016 P.T.O.
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									
									DAS 21 9-89 SEP 16 2016
									DAS 21 9-89 SEP 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: R274 Date: OCT 18 2016Work Order update only ☐

Work Order: <u>149955</u> Part No. <u>D5283-043</u> NCR No. <u>16-6103</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16-09-15</u>		Step #: <u>210</u>		QTY Effective: <u>8</u>		MRB (QSI042) Approval DAS 9 9-89 <u>16-09-15</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
Port found in stores finish but not painted/Finish <u>NO COMPLETED</u>				- remove and keep bearing D261 FF - clad line and powder coat as per drawing D5283/BEB - re install bearing D261 by press fit and stake at 4 location. <u>M135418</u> START: <u>7:50</u> 8/16-09 Q.T: <u>320°</u> FINISH: <u>7:20</u>																																																																			
				Completed By: <u>DAS 38</u> <u>16/09/16</u> Lead hand / Supervisor Approval Verification <u>DAS 38</u> <u>9-89</u> SEP 16 2016 QC / QA Coordinator Approval <u>DAS 9</u> <u>9-89</u> <u>16-09-23</u>																																																																			
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August 16, 2016 9:24:03 AM

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D5283-043

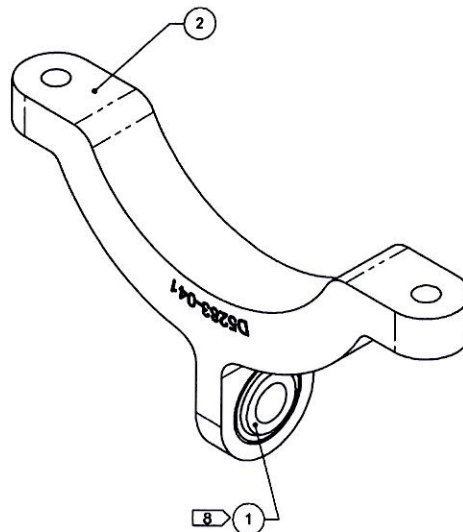
Required Date: 8/23/2016

Required Qty: 10.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No				Each	20.0000		10			
D2611 Bearing													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST008A	134006	ok	20						
				134776			20						
D5283-3P		Purchased	No				Each	0.0000					
D5283-3P Basket Clamp													
M6061T6B30000X01.500		Purchased	No				f	12.8270		4.842105			
M6061T6B30000X01.500 6061-T6 Bar 3.00 x 1.50													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT004			12.827						
				m133699			0.827						
				m134984			12						

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

AUG 15 2016

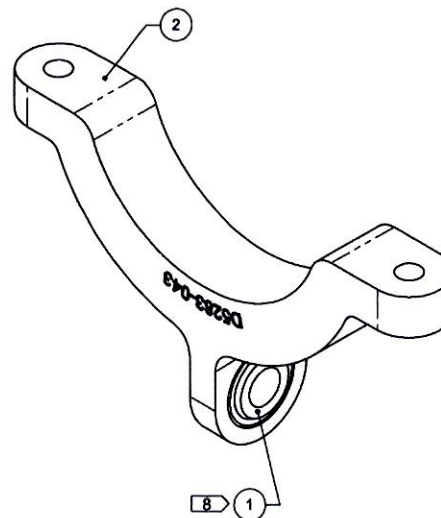
Sta 149955

RELEASED
2015-07-20
ERN 15-607

A	NEW ISSUE	DB	15.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 1 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



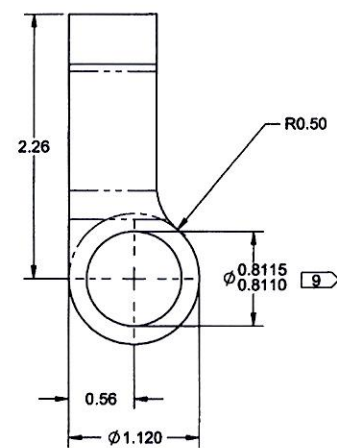
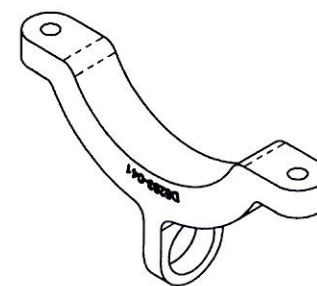
D5283-043 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 2 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
	DATE	15.06.30	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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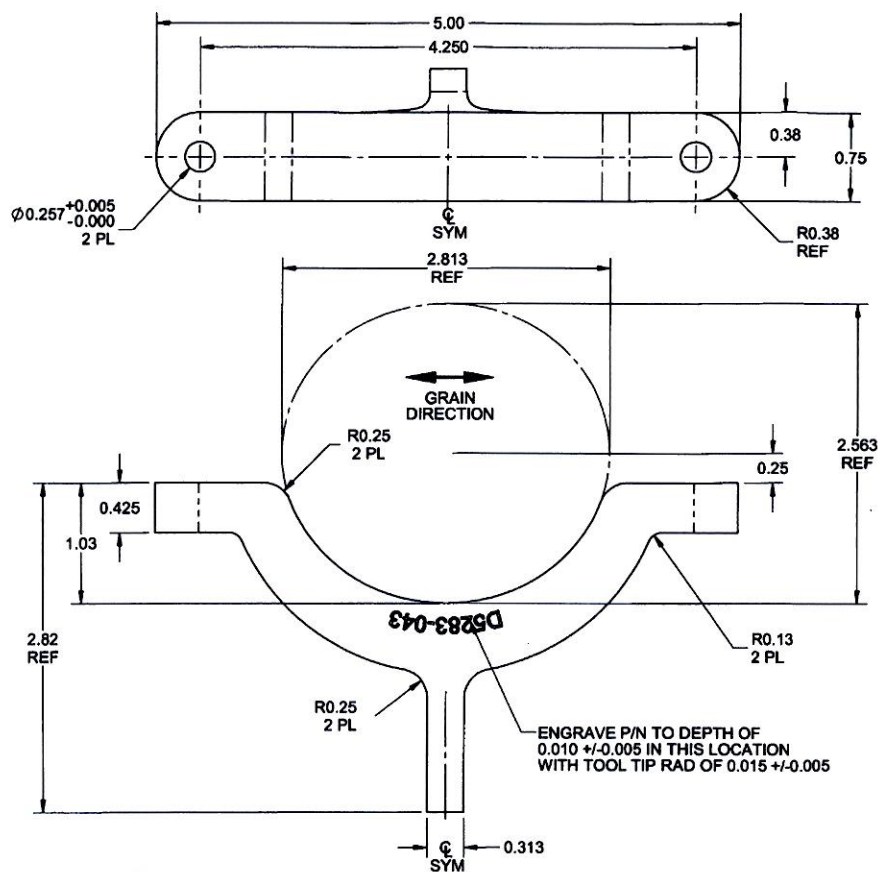


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NOTES:

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
 - 7) WEIGHT: 0.24 lbs
 - 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
 - 9) MASK BEARING BORE PRIOR TO POWDER COAT

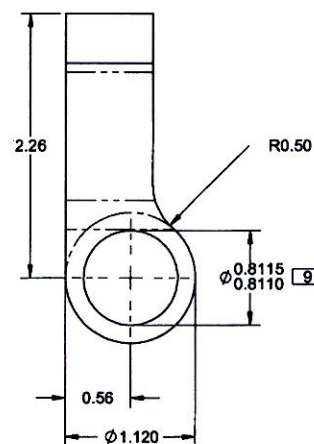
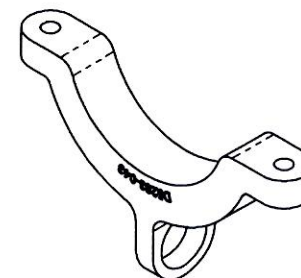
APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 3 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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D5283-3 BASKET CLAMP

NOTES:

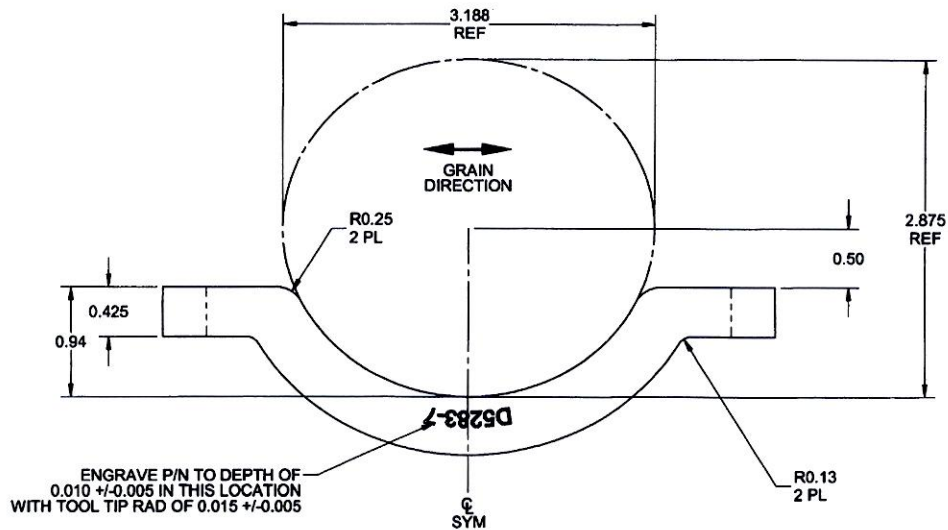
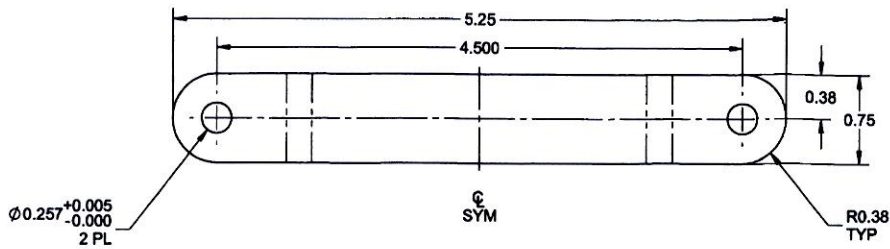
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-043 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-3.Rev A. STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT



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DRAWN	DB	
CHECKED	AP	
MFG. APPR.	JLM	
APPROVED	WM	
DE APPR.	DS	
DATE 15.06.30		REV. A SHEET 4 OF 6 SCALE NTS

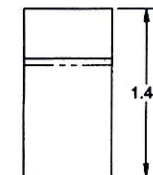


ENGRAVE P/N TO DEPTH OF
0.010 $\pm$ 0.005 IN THIS LOCATION
WITH TOOL TIP RAD OF 0.015 $\pm$ 0.005

D5283-7 BASKET CLAMP

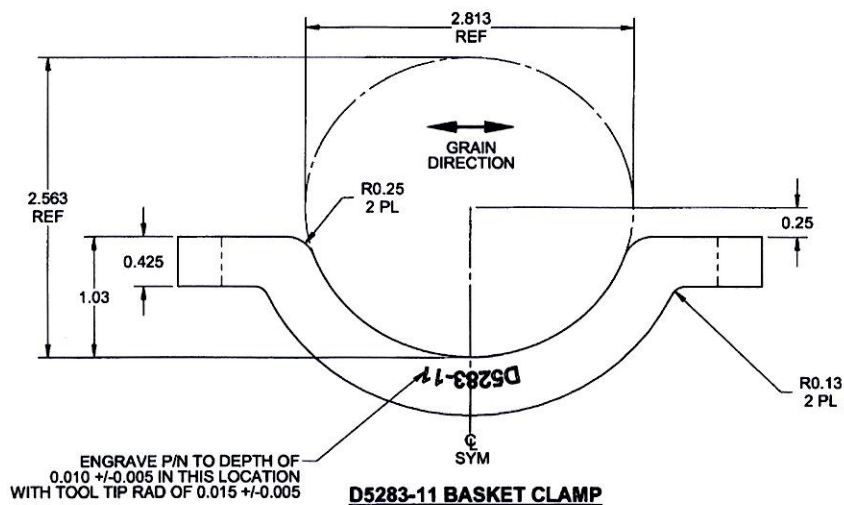
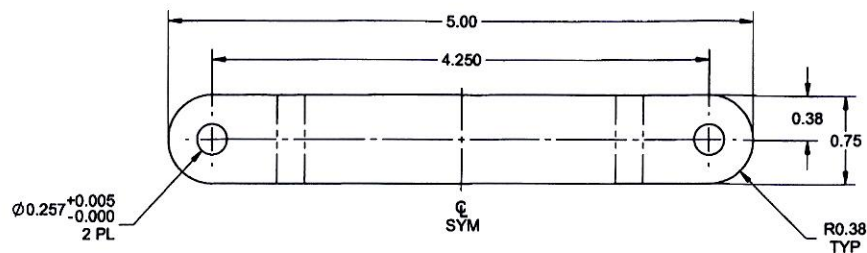
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.STEP

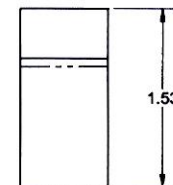
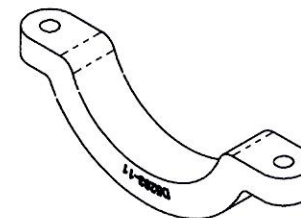


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	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 5 OF 8
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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D5283-11 BASKET CLAMP



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A.STEP

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DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
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2015-07-20



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21355
Date: Aug 24, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
--	---

Order No.: 33342	Sold By: VanDenYssel, David
-------------------------	------------------------------------

Shipped By: your truck	Ship Date: Aug 24, 2016
-------------------------------	--------------------------------

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5283-1 Basket Clamp, no finishing Set-up fee is applied to quantities below 25	Each	10 1	10	1
D5283-3 Basket Clamp, no finishing Set-up fee is applied to quantities below 25 ***One of these parts is questionable, please check and let us know if you except it. (marked in a bag) One piece was scrapped***	Each	10 1	9	1 1

25/8/16
SD

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____	Thank you for your order!
-------------------	----------------------------------



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D5283-1	Lug	33342
9	D5283-3	Lug	33342

MATERIAL: supplied by DART B127892

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, August 24, 2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33342**

Purchase Order Date 8/17/2016

PO Print Date 8/17/2016

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

AUG 18 2016

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D5283-1P	Basket Clamp	9/2/2016 Yes 9/2/2016	FN	10.00 Each	\$30.75	\$307.50
AS PER DWG D5283 REV. A B149956 MAT'L CUT TO SIZE: 6061-T6 BAR 3" X 1.5" X 10 PCS M133699 SET UP FEE INCLUDED IN PRICE OF CLAMPS							
2	D5283-3P	Basket Clamp	9/2/2016 Yes 9/2/2016	FN	10.00 Each	\$28.75	\$287.50
AS PER DWG D5283 REV. A B149955 MAT'L CUT TO SIZE: 6061-T6 BAR 3" X 1.5" X 10 PCS M133699 SET UP FEE INCLUDED IN PRICE OF CLAMPS							
Line Total:							\$307.50

Note:

8/17/2016